



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D206-642-241
Job Sheet 195714



Part No: D206-642-241

Job Qty: 1 pcs

Part Name: Replacement Skidtube, High Gear with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/30/19

Job Tracking No:

Due Date: 7/5/19

Created By: Kimberley Guerin

Type: Stock

Description:

Note: DWG REV F(DEO) IPP Rev: 04.12.02 Revised procedural steps KJ/JLM IPP RevP: revise and update route/bom DD 10.01.06 verf:EC IPP rev Q 10.02.19 per PAR 09-043 EC verified by: DD IPP Rev:R 12.11.22 now swage per ecn12-679 DD verf:JLM IPP Rev:S 14.04.24 ECN14-520 DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	7/5/19		0.00	2.22	Skidtubes - 1		DD
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	QC 5	1 pcs	7/5/19		0.00	0.00	QC 5 - 10		JUN 25 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22	68-6	
							QC 5 - 24	24	
							QC 5 - 3	DAS	
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	QC 9	1 pcs	7/5/19		0.00	0.00	QC 9 - 10		JUN 25 2019
							QC 9 - 18		
							QC 9 - 24	DAS	
							QC 9 - 43	24	
							QC 9 - 50	9-89	
							QC 9 - 9		

Plex 5/30/19 9:07 AM Dart, Guerin, Kimberley

140 Handfinish - 1-1 Chemical- B4B 1
pcs

7/5/19

0.00 0.33

Handfinish - 1 - 1 - B4B

Handfinish - 1 - 2 - B4B

Handfinish - 1 - 3 - B4B

Handfinish - 1 - 4 - B4B

Handfinish - 1 - 5 - B4B

Handfinish - 1 - 6 - B4B

Handfinish - 1 - 7 - B4B

Handfinish - 1 - 8 - B4B

Handfinish - 1 - 9 - B4B

Handfinish - 1 - 10 -
B4BHandfinish - 1 - 11 -
B4BHandfinish - 1 - 12 -
B4BHandfinish - 1 - 13 -
B4BHandfinish - 1 - 14 -
B4BHandfinish - 1 - 15 -
B4BHandfinish - 1 - 16 -
B4BHandfinish - 1 - 17 -
B4BHandfinish - 1 - 18 -
B4BHandfinish - 1 - 19 -
B4BHandfinish - 1 - 20 -
B4BHandfinish - 1 - 21 -
B4BHandfinish - 1 - 22 -
B4B

JUN 26 2019

150 QC 7

1
pcs

7/5/19

0.00 0.00

QC 7 - 10

QC 7 - 13

QC 7 - 14

QC 7 - 15

QC 7 - 17

QC 7 - 18

QC 7 - 19

QC 7 - 2

QC 7 - 28

QC 7 - 3

QC 7 - 30

QC 7 - 34

QC 7 - 36

QC 7 - 37

QC 7 - 41

QC 7 - 47

QC 7 - 48

QC 7 - 51

QC 7 - 58

QC 7 - 59

QC 7 - 60

QC 7 - 9

QC 7 - 68

QC 7 - 50

QC 7 - 67

QC 7 - 40

160 Skidtubes - 2 - B4B	1 pcs	7/5/19	0.00 2.50	QC 7 - 24	
				QC 7 - 43	
				Skidtubes - 1 - B4B	DD
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
180 Skidtubes - 3 - B4B	1 pcs	7/5/19	0.00 2.50	Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
				Skidtubes - 1 - B4B	DD
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	
190 QC 5	1 pcs	7/5/19	0.00 0.00	Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	BB
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
200 Skidtubes - 4 - B4B	1 pcs	7/5/19	0.00 2.50	QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				Skidtubes - 1 - B4B	DD
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
220 QC 9	1 pcs	7/5/19	0.00 0.00	Skidtubes - 5 - B4B	BB
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
				QC 9 - 10	
				QC 9 - 18	
				QC 9 - 24	DA5
				QC 9 - 43	43
230 QC 5	1 pcs	7/5/19	0.00 0.00	QC 9 - 50	9-25
				QC 9 - 9	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
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				QC 5 - 22	
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				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	

240 Handfinish - 2-1 Pressure- B4B	1 pcs	7/5/19	0.00 0.33	QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				Handfinish - 2 - 1 - B4B	
250 Powdercoat - 1 White Gl(A)- B4B	1 pcs	7/5/19	0.00 0.28	Handfinish - 2 - 2 - B4B	
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
				Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
260 QC 3	1 pcs	7/5/19	0.00 0.00	Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
				QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
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				QC 3 - 24	
270 Handfinish - 3-1- WingWalk- B4B	1 pcs	7/5/19	0.00 1.06	Handfinish - 3 - 1 - B4B	
				Handfinish - 3 - 2 - B4B	
				Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
300 QC 5	1 pcs	7/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
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				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
310 Packaging 3-1 - Stock - B4B	1 pcs	7/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	

DAS
40
9-89

JUL 19 2019

ML 19-7-22

BL 19-7-23

ML 19-7-26

ML 19-9-9

DAS
40
9-89

SEP 10 2019

				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
315	DC - 1 - B4B	1	7/5/19	0.00 0.00	DC - 1 - B4B
		pcs			DC - 2 - B4B
320	QC 21 - FG	1	7/5/19	0.00 0.00	QC 21 - FG - 21
		pcs			QC 21 - FG - 70
					QC 21 - FG - 53

SEP 16 2019

SEP 16 2019

DAS

70

9-89

Part Op 110 - 1-Deburr Fwd edge of tube 2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650 3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required. 4-Grind weld flush to cap on top surface only. 5-Cut Aft end as per dwg D2650 from front of tube and Deburr 6-Remove inner indexing ridge on Aft end of skid tube as per Dwg D2650 7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025. 8-Drill pilot holes using Dt 8167. 9-Locate DT8732A from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732B & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732A & doubler leaving DT8732B for added support. 10- Drill D3286-1 doubler rivet holes in tube using # 30 drill, spot drilling doubler at the same time. 11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads. 12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650 13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder 14-Remove indexing edge using DT9779 as per Dwg D2650. Leave 0.070" wall minimum. 15-C'sink GHW rivet holes as per Dwg D2650 16-Open crossbolt holes to Ø0.375" 17-Drill pilot holes using DT8028-3, then open to Ø0.297" as per Dwg D2650. Open Aft cap hole #6. 18- Ream crossbolt spacer holes to 0.377". 19-

120 - (QC5- Inspect part completeness to step on W/O)
 130 - (QC9- Inspect visual per QSI004- Fusion Welds)
 150 - (QC7-Inspect Chemical Conversion Coat)
 160 - 1- Open and c'sink one crossbolt spacer holes as per Dwg D2650 (DEO Detail B)(without cutting fluid) 2-Deburr and blow out all chips from inside the tube
 180 - 1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required 2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up.Allow 12 Hrs. cure time before cutting
 190 - (QC5- Inspect part completeness to step on W/O)
 200 - 1-Remove alodine in one area per DEO detail B from around hole and prepare for welding 2-Prep per QSI 005 and Insert one D2649 crossbolt spacer. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod. 3-Grind welds flush as per Dwg D2650. 4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each hole to Ø0.402" before welding other side. Use SS rod as required. 5- Insert D4720-1 Spacer. Swage to 0.313" X 0.75" DP per QSI 002. Trim and grind flush per QSI 002

- 220 - (QC9- Inspect visual per QSI004- Fusion Welds)
 230 - (QC5- Inspect part completeness to step on W/O)
 240 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.
 250 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. START TIME: _____ FINISH TIME: _____
 260 - (QC3- Inspect Part Finish)
 270 - (Wing Walk as per dwg QSI005 4.4 Batch 425143) - Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. 2-Install D2680-041 Nut Plate as per Dwg D2650
 300 - (QC5- Inspect part completeness to step on W/O)
 310 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP D206-642-241
 315 - Photocopy bluefile & type labels per PPP D206-642-241 CHG007
 320 - (QC21- Final Inspection - Work Order Release)

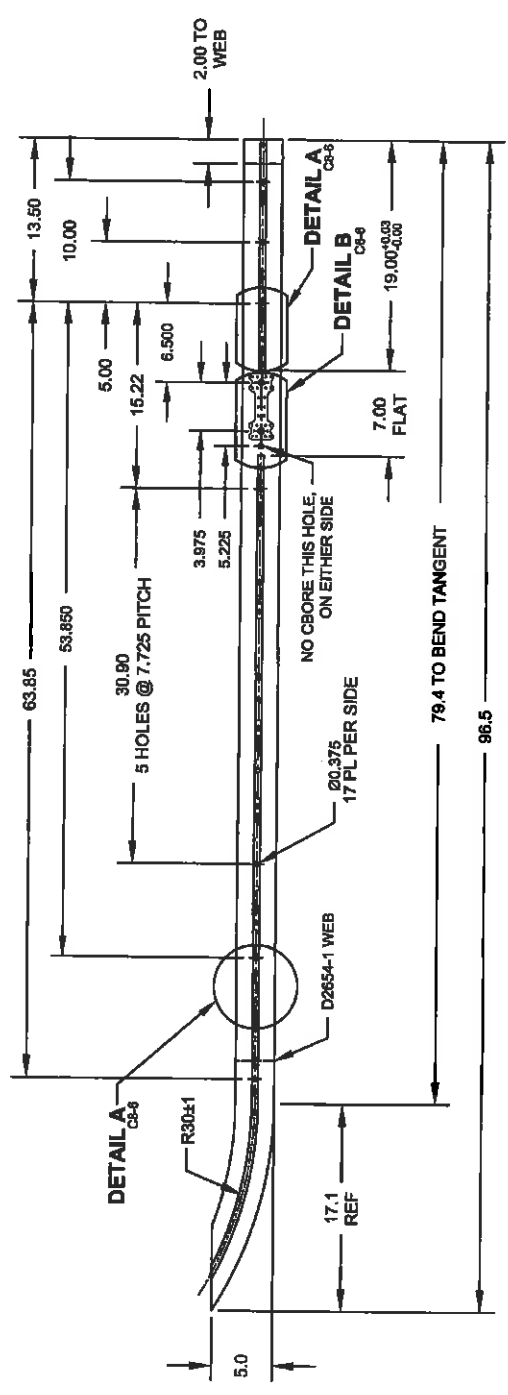
Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2620	Skidtube, 206 Skidtube	1 pcs (1 ea)	110-Skidtubes - 1	5189572
D2647	Cap	1 pcs (1 ea)	110-Skidtubes - 1	5166098
D3286-1	Doubler	2 pcs (2 ea)	110-Skidtubes - 1	5176117
CR3212-4-04	Cherry Rivet	52 Ea (52 ea)	180-Skidtubes - 3 - B4B	5161983
D2654-3	Web	1 pcs (1 ea)	180-Skidtubes - 3 - B4B	5167121
D2649	Cross Bolt Spacer	1 pcs (1 ea)	200-Skidtubes - 4 - B4B	5050570
D3286-3	Spacer	2 pcs (2 ea)	200-Skidtubes - 4 - B4B	5173052
D4720-1	Spacer	17 pcs (17 ea)	200-Skidtubes - 4 - B4B	5173039
ALS4-1032-130	Rivnut	44 Ea (44 ea)	270-Handfinish - 3-1- WingWalk-B4B	5057257
D2646	Aft Cap	1 pcs (1 ea)	270-Handfinish - 3-1- WingWalk-B4B	5160607
D2651-1	Plug	18 pcs (18 ea)	270-Handfinish - 3-1- WingWalk-B4B	5196044
D2651-3	O-Ring	18 pcs (18 ea)	270-Handfinish - 3-1- WingWalk-B4B	5180320
D2680-041	Nut Plate	1 pcs (1 ea)	270-Handfinish - 3-1- WingWalk-B4B	5195622
D3537-1	Wearpad	4 pcs (4 ea)	270-Handfinish - 3-1- WingWalk-B4B	5183621
D3537-3	Wearpad	1 pcs (1 ea)	270-Handfinish - 3-1- WingWalk-B4B	5174518
D4956-13	Wearplate Fwd	1 pcs (1 ea)	270-Handfinish - 3-1- WingWalk-B4B	X 5206197
D4956-21	Wearplate Center	1 pcs (1 ea)	270-Handfinish - 3-1- WingWalk-B4B	X 5206197
D4956-33	Wearplate Aft	1 pcs (1 ea)	270-Handfinish - 3-1- WingWalk-B4B	5162892
MS27039-1-08	Screw	46 Ea (46 ea)	270-Handfinish - 3-1- WingWalk-B4B	5166924-1
MS27039-4-06	Screw	1 Ea (1 ea)	270-Handfinish - 3-1- WingWalk-B4B	5170879
NAS1149D0332J	Washer	46 Ea (46 ea)	270-Handfinish - 3-1- WingWalk-B4B	5055527
NAS1149D0463J	Washer	1 Ea (1 ea)	270-Handfinish - 3-1- WingWalk-B4B	5098277
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	270-Handfinish - 3-1- WingWalk-B4B	51732660
CR3212-4-03	Cherry Rivet	2 Ea (2 ea)	270-Handfinish - 3-1- WingWalk-B4B	X 5197646

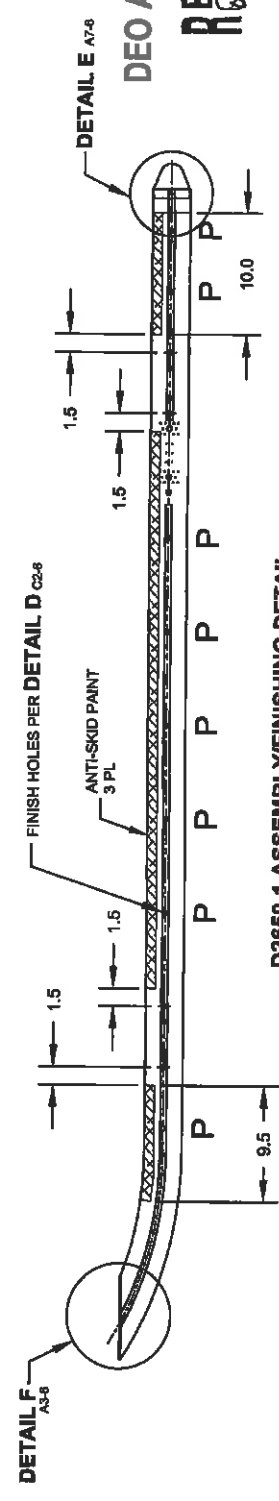
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2620	1	4	0
	D2647	1	43	0
	D3286-1	2	36	0
180-Skidtubes - 3 - B4B	CR3212-4-04	52	631	0
	D2654-3	1	10	0
200-Skidtubes - 4 - B4B	D2649	1	70	0
	D3286-3	2	24	0
	D4720-1	17	222	0
270-Handfinish - 3-1- WingWalk-B4B	ALS4-1032-130	44	7,594	0
	CCR264SS3-3	2	159	0
	CR3212-4-03	2	84	0
	D2646	1	33	0
	D2651-1	18	95	0
	D2651-3	18	304	0
	D2680-041	1	11	0
	D3537-1	4	68	0
	D3537-3	1	18	0
	D4956-13	1	5	0
	D4956-21	1	0	0
	D4956-33	1	2	0
	MS27039-1-08	46	467	0
	MS27039-4-06	1	95	0
	NAS1149D0332J	46	3,596	0
	NAS1149D0463J	1	3,447	0
Part Specifications				
Specifications could not be found.				

Plex 5/30/19 9:07 AM Dart.Guerin.Kimberley

1 2 3 4 5 6 7 8



D2650-1 BENDING/DRILLING DETAIL



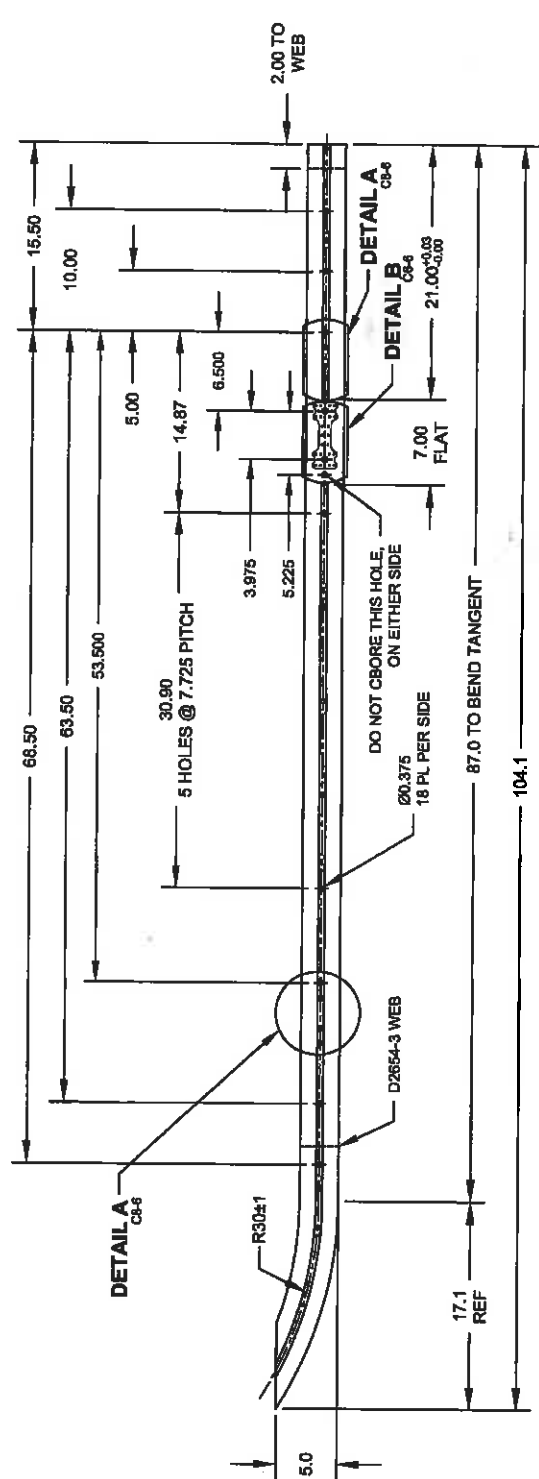
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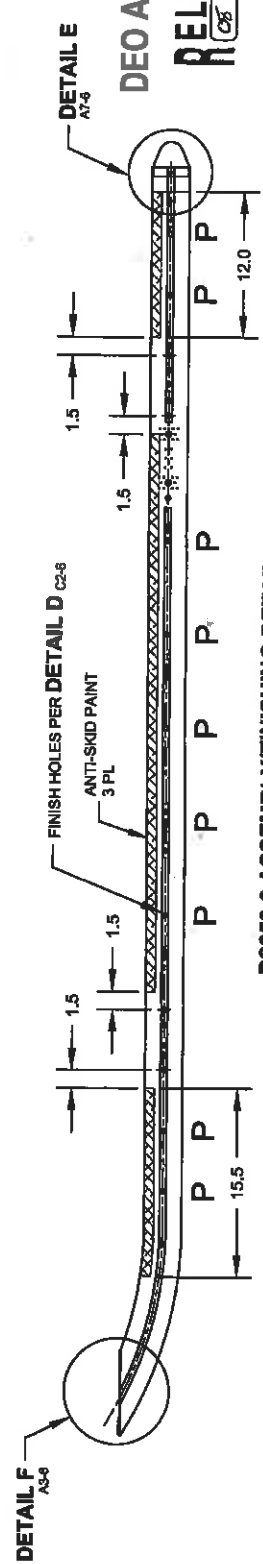
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DRAWN	AJS	PORT HADLOCK, WA
CHECKED		DRAWING NO. D2650
MFG. APPR.		REV. F SHEET 2 OF 6
APPROVED		TITLE 206/407 SKIDTUBE ASSEMBLIES
DE APPR.		SCALE NTS
DATE	08.08.08	NTS

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D2650-3 BENDING/DRILLING DETAIL

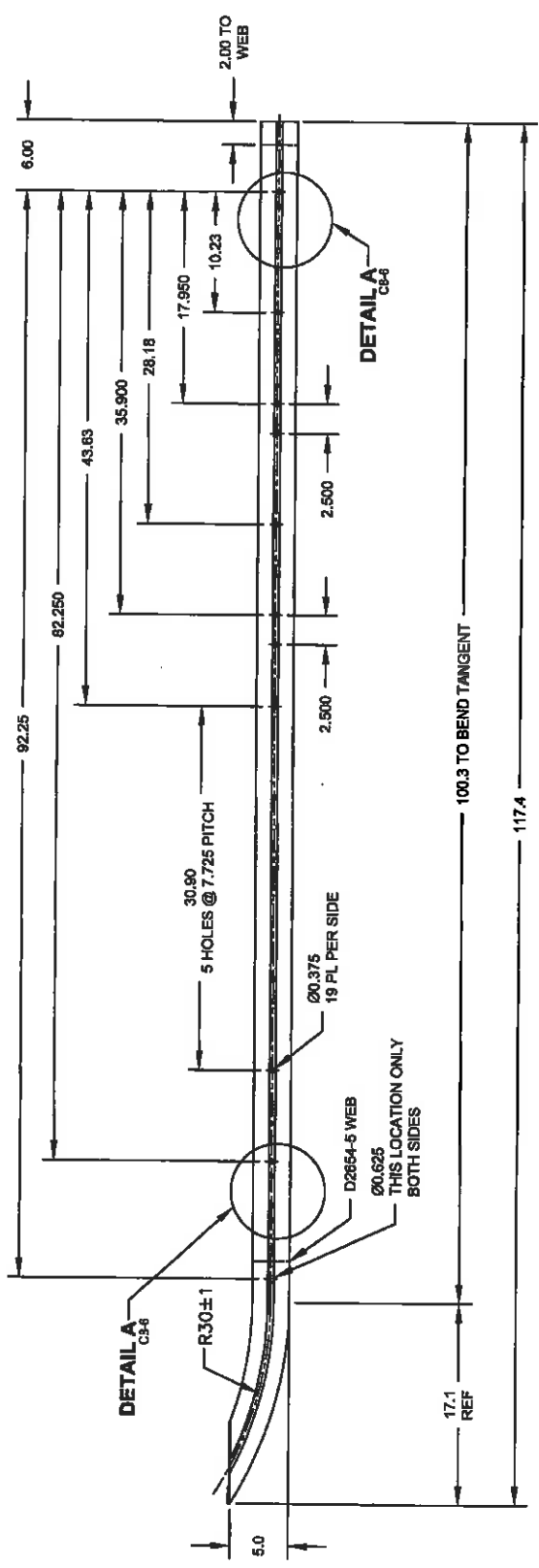


D2650-3 ASSEMBLY/FINISHING DETAIL

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DRAWN	AJS	PORT HADLOCK, WA
CHECKED		
MFG. APPR.	D2650	REV. F
DE APPR.		SHEET 3 OF 6
DATE	08.08.08	SCALE
		NTS
		206/407 SKIDTUBE ASSEMBLIES
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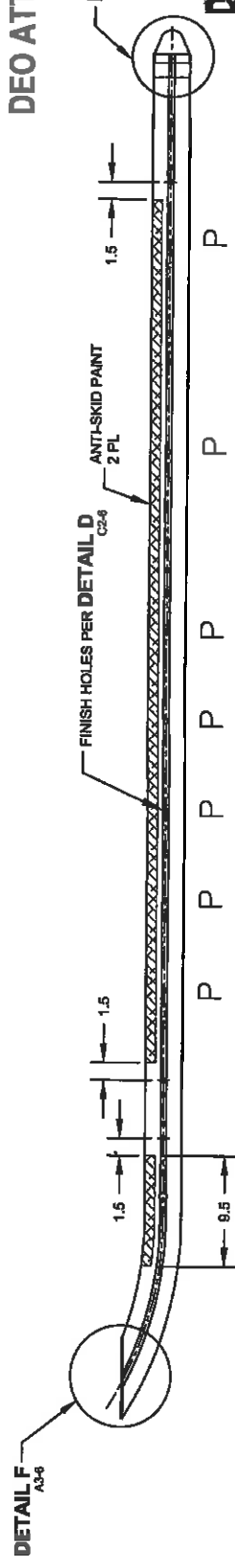
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D2650-5 BENDING/DRILLING DETAIL

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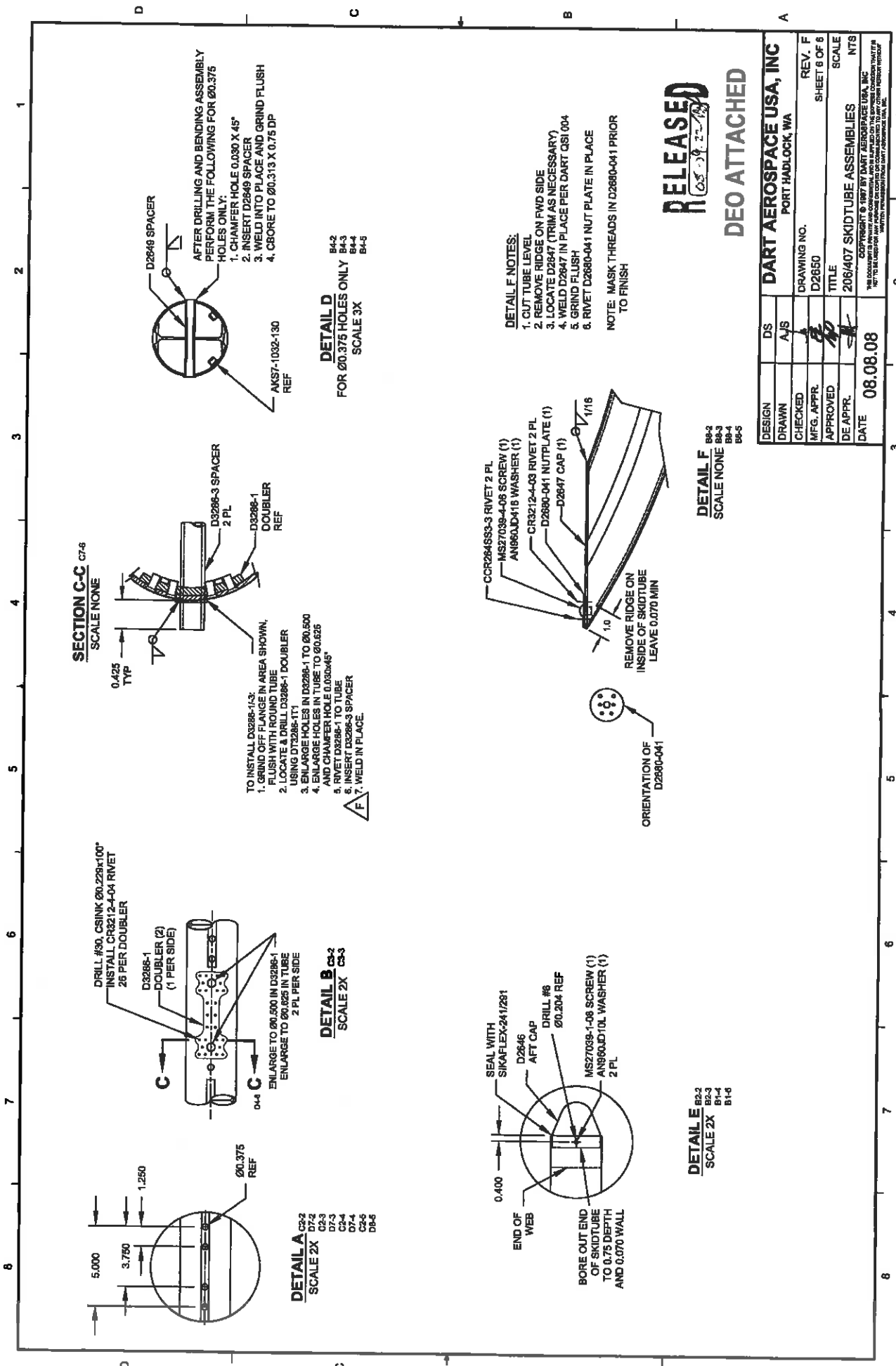


D2650-5 ASSEMBLY/FINISHING DETAIL

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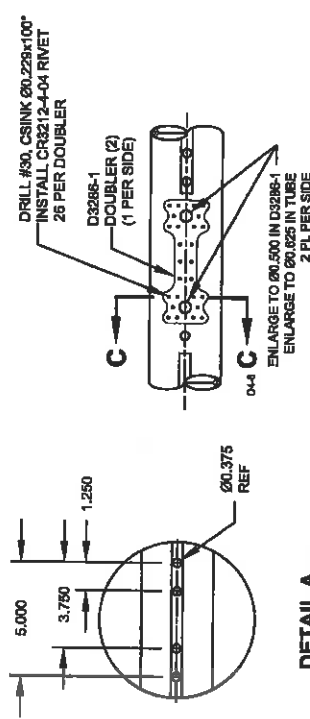
DESIGN	DS	DART AEROSPACE USA, INC
DRAWN	AJS	PORT HADLOCK, WA
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APPROVED		TITLE 208/407 SKIDTUBE ASSEMBLIES
DE APPR.		SCALE NTS
DATE	08.08.08	COMPONENT IS NOT BY DART AEROSPACE USA, INC

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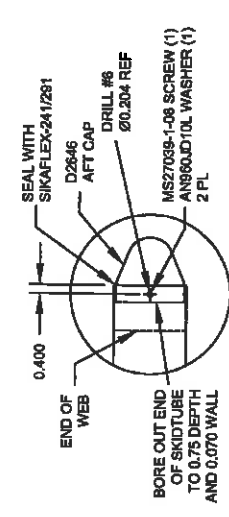
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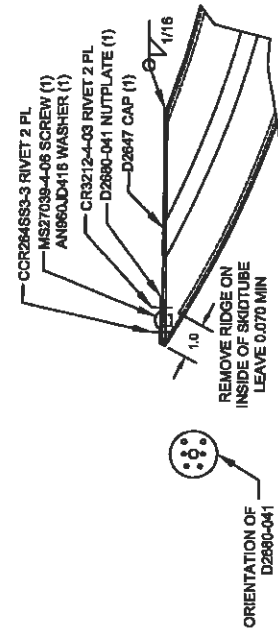


DETAIL A
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DETAIL B
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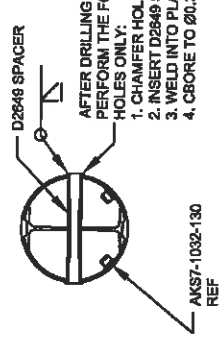


DETAIL E
SCALE 2X
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DETAIL F
SCALE NONE
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DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X
B4-2
B4-3
B4-4
B4-5



- DETAIL F NOTES:
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2647 (TRIM AS NECESSARY)
 4. WELD D2647 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D2680-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

RELEASED
05-09-2003
DEO ATTACHED

DESIGN	DS	DART AEROSPACE USA, INC
DRAWN	AJS	PORT HADLOCK, WA
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	08.08.08	
DRAWING NO.	D2650	REV. F
TITLE	206/407 SKIDTUBE ASSEMBLIES	SHEET 8 OF 8
SCALE	NTS	
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THIS DOCUMENT IS UNCLASSIFIED AND IS NOT TO BE RELEASED OUTSIDE THE DART AEROSPACE USA, INC FACILITY		

DRAWING NO. D2650	TITLE 206/407 SKIDTUBE ASSEMBLIES	REV. F	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2650-F-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN DATE 12.10.12	CHECKED DATE 12.10.12	DATE 12.10.12	MFG. APPR. DATE 12.10.12	APPROVED DATE 12.10.22	DE APPR. DATE 12.10.22		

PURPOSE:

CHANGE C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

IS:

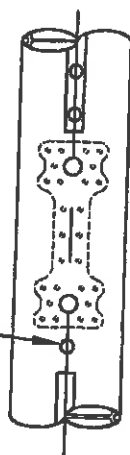
QTY	QTY	QTY	QTY	QTY	DESCRIPTION
-1	-3	-5	-7		
1	1	0	0	D2649	CROSS BOLT SPACER
16	17	19	23	D4720-1	SPACER

WAS:

17	18	19	23	D2649	CROSS BOLT SPACER
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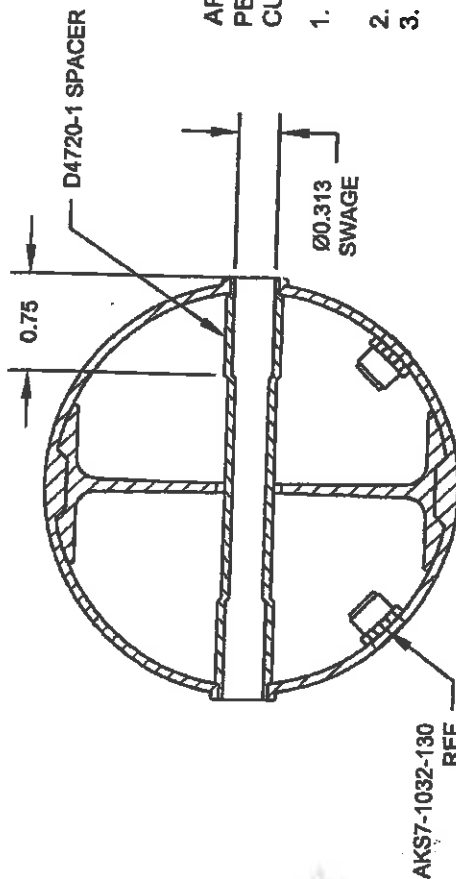
ADD DETAIL G BELOW, WHICH IS THE SAME SECTION VIEW AS DETAIL D OF DWG. C'BORED HOLES ARE NOW SWAGED PER DETAIL G BELOW. FOR THE Ø0.375 HOLE THAT IS NOT C'BORED, WELD PER DETAIL D OF DWG (SEE AMENDED DETAIL B FOR REFERENCE).

D2649 SPACER,
WELD PER DETAIL D OF DWG
BUT DO NOT C'BORE



DETAIL B

AMENDMENT TO DETAIL B
NOT TO SCALE



DETAIL G

FOR Ø0.375 HOLES ONLY
FOR HOLES THAT ARE CURRENTLY C'BORED ONLY
NOT TO SCALE

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES THAT ARE
CURRENTLY C'BORED:

1. INSERT D4720-1 SPACER, 16 PL (-1) OR 17 PL (-3)
OR 19 PL (-5) OR 23 PL (-7)
2. SWAGE TO Ø0.313 X 0.75 DP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

RELEASED
2012-11-16